

FORM U-1A MANUFACTURER'S DATA REPORT FOR PRESSURE VESSELS
(Alternative Form for Single Chamber, Completely Shop-Fabricated Vessels Only)
As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

86230

1. Manufactured and certified by Continental Fabricators, Inc. 5601 West Park Ave. St. Louis, MO 63110
(Name and address of manufacturer)

2. Manufactured for Fluor Daniel, Inc. 100 Fluor Daniel Dr. St. Louis, MO 63107
(Name and address of purchaser)

3. Location of installation Monsanto Company Sauget, IL
(Name and address of user)

4. Type Horizontal Tank CC-3071A --- 463-L MAY 22 1990 1990
(Horizontal or vertical tank) (Manufacturer's serial No.) (CRN) (Drawing No.) (Date of construction) (Year built)

5. The chemical and physical properties of all parts meet the requirements of material specifications of ASME BOILER AND PRESSURE VESSEL CODE. The design, construction, and workmanship conform to ASME Rules, Section VIII, Division 1, 1988
to 1988
(Addenda (Date)) (Code Case Nos.) (Special Service per UG-120(d))

6. Shell: SA240-T316 .250" --- 5'-5 1/2" 15'-0" T/T
(Matl. (Spec. No., Grade)) (Nom. Thk. (in.)) (Corr. Allow. (in.)) (Diam. I.D. (ft. & in.)) (Length (overall) (ft. & in.))

7. Seams: Dbl Welded Butt Spot 85% --- --- Dbl Welded Butt Spot 2
(Long. (Welded, Dbl., Singl., Lap, Butt)) (R.T. (Spot or Full)) (Eff. (%)) (H.T. Temp. (°F)) (Time (hr)) (Girth (Welded, Dbl., Singl., Lap, Butt)) (R.T. (Spot, Partial, or Full)) (No. of Courses)

8. Heads: (a) Matl. SA240-T316 (b) Matl. ---
(Spec. No., Grade) (Spec. No., Grade)

	Location (Top, Bottom, Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure (Convex or Concave)
(a)	Ends	.1875"	0	60"	4"	---	---	---	---	Concave
(b)										

If removable, bolts used (describe other fastenings) ---
(Matl., Spec. No., Gr., Size, No.)

9. MAWP 61 psi at max. temp. 250 °F
Min. design metal temp. -15 °F at 61 psi. Hydro. test pressure 92 (Horizontal) psi.

10. Nozzles, inspection and safety valve openings:

Purpose (Inlet, Outlet, Drain)	No.	Diam. or Size	Type	Matl.	Nom. Thk.	Reinforcement Matl.	How Attached	Location
Manway	1	24" 150#	R.F. S.O.	SA240-T316	.250"	SA240-T316	Welded	Shell
	1	4" 150#	R.F. W.N.	SA312-T316	.237"	SA240-T316	Welded	Shell
	4	3" 150#	R.F. W.N.	SA312-T316	.216"	---	Welded	Various
	6	2" 150#	R.F. W.N.	SA312-T316	.154"	---	Welded	Various

11. Supports: Skirt No Lugs --- Legs --- Other 2 Saddles Attached Shell - Welded
(Yes or no) (No.) (No.) (Describe) (Where and how)

12. Remarks: Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of the report: ---
(Name of part, item number, Mfr's name and identifying stamp)

Waste Water Tank - Item 221.0944 Exempt from impact testing per UHA-51a
24" Manway Flanges are SA-105 Overlayed with T-316 S.S.
One of the above nozzles may be used for pressure relief.

CERTIFICATE OF SHOP COMPLIANCE

We certify that the statements made in this report are correct and that all details of design, material, construction, and workmanship of this vessel conform to the ASME Code for Pressure Vessels, Section VIII, Division 1, "U" Certificate of Authorization No. 27 expires Apr 30, 1990.
Date 3-23-90 Co. name Continental Fabricators, Inc. Signed J.S. Adams
(Manufacturer) (Representative)

CERTIFICATE OF SHOP INSPECTION

Vessel constructed by Continental Fabricators, Inc. at St. Louis, Missouri

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of Missouri and employed by Commercial Union Insurance Co.

have inspected the component described in this Manufacturer's Data Report on 3/28, 19 90, and state that, to the best of my knowledge and belief, the Manufacturer has constructed this pressure vessel in accordance with ASME Code, Section VIII, Division 1. By signing this certificate neither the Inspector nor his employer makes any warranty, expressed or implied, concerning the pressure vessel described in this Manufacturer's Data Report. Furthermore, neither the Inspector nor his employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection.

Date 3/28/90 Signed Richard D. Burch Commissions 1437967 MO-0186
(Authorized Inspector) (Not a Board (incl. endorsements), State, Prov. and No.)

ION RD

2894

CEP BY

Continental Abrasive Inc.

IS, M

WP

61

PSI

250

PF

PF

— 25

PF

61

PSI

CUST. PO. NO.

BT280-D15066

CC307A

YR.

1990

ITEM 221.0914 — REG. NO. 111145002

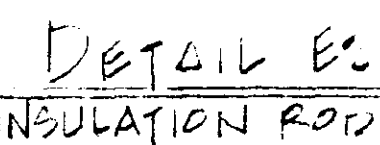
1990
SI

50660
FLUOR ENGINEERING

86230



(2) REQ'D AS SHOWN
(1) REQ'D OPP HAND



NOZZLE SCHEDULE

CERTIFIED
FOR FABRICATION
CONTINENTAL
FABRICATORS, INC.
ST. LOUIS, MO.

Date _____

By _____

REF ID: A61061

REVISION

- ### GENERAL NOTES
1. ALL BOLT HOLES TO STEAMLINE WORKING PRESSURE CENTERLINES.
 2. ALL NOZZLES TO BE TRIMMED FLARE AND BEING GROUNDED TO A 1/16" RADIUS.
 3. ALL INTERNALS SHALL HAVE CONTINUOUS FILLED WELDS.
 4. MANWAY REINFORCING PAD SHALL HAVE 1/4" THICK HOLE AND TESTED WITH SOAP BUBS AND AIR AT 15 PSI. FILL HOLE WITH WELDING RODS AND TEST.
 5. CLEAN EXTERIOR SURFACES PER ASTM-SPE. (NON-MERCIAL BLAST) AND APPLY ONE COAT OF PORTER ZINC-LOCK 351 TO A MINIMUM OF 0.001 IN. D.F.T. TO SADDLE SUPPORTS, INSULATION AND AND STIFFENER RINGS AND MANWAY FLANGES.
 6. INTERIOR OF VESSEL TO BE FREE OF ALL DEBRIS MATTER INCLUDING SLAG, DIRT AND WATER BEFORE SHIPMENT.
 7. ALL NOZZLES SHALL BE BLANKED WITH WOOD COVERS FOR SHIPMENT.

GENERAL SPECIFICATIONS

DESIGN, CONSTRUCTION AND TEST IN ACCORDANCE WITH THE ASME CODE.

SECTION MILL DIV 1 1986 EDITION: 1988 ADD _____

INSPECTION: INS. CO. YES CUSTOMER YES

ASME STAMPING YES N.B. YES

INTERNAL DESIGN PRESS. 40 PSI @ 250/-15

EXTERNAL DESIGN PRESS. FV PSI @ 250

EFFICIENCY: HEAD 85% SHELL 85%

CORROSION ALLOWANCE - 0"
MAWP W1 PSI @ 150 °F LIMITED BY HEAD
* MDMT - 15 °F @ W1 PSI
RADIOGRAPH SPOT X-RAY

HEAT TREATING NOT REQ'D

SHOP TEST PRESSURE HYDROTEST @ 92 PSI IN
HORIZONTAL POSITION

MATERIAL SPECIFICATIONS:

HEADS SA-240-316 2/3

SHELL SA-240-316 4/3

REINFORCEMENT A2U

SUPPORTS A19L

FLANGES SA-19L-316 5/4, MN BLVD SA-105

NOZZLES: PIPE SA-312-316 7/5, PLATE SA-240-316 3/4

INTERNALS SA-312-316 2/3, SA-240-316 3/4

COUPLINGS

BOLTS/STUDS SA-193-87

GASKETS CJAR-DEK 9800

NUTS SA-194-2H

ESTIMATED SHIPPING WEIGHT 4100 LB
WEIGHT FULL OF WATER 25,600 LB
TAG ITEM 221.0944 - IL REG. NO ILLU146000
NO. REQ'D ONE

 **Continental**
Boiler Works, Inc.
5620 West Park Avenue Saint Louis, Missouri 63

EAST NCB PROCESS # 86230
WASTE WATER TANK
ITEM 721,094 - 1.000 NO. 111145002
FOR FLOOR DAMEL / MANSARD
LOCATION SAUGET, IL.

DR COX	APPRO.	SCALE NONE	CUSTOMER NO. B-780-DI
CH 1A	PART 66 GEN NOTES	DATE 12-6-89	3060
ORDER NO. CC-3071A	SHEET NO. 1B	TOTAL 2B	DRAWING NO. 4L3-L